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D350-600-542
Job Sheet 187926



Part No: D350-600-542

Job Qty: 1 pcs

Part Name: Sliding Door Hinge, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/21/18

Job Tracking No:

Due Date: 1/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D350-600 REV E, DSI9814 REV A IPP RevA: New issue DD verified by:EC IPP REV B: PER DSI 9814
REV.A 18/12/14 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	1/8/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		
							Packaging 1 - 32		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120 QC 4	1 pcs	1/8/19	0.00 0.00	Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				QC 4 - 26	
				QC 4 - 28	
				QC 4 - 38	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	DAS
				QC 4 - 69	69
				QC 4 - 9	9-89
130 Packaging 3-1 - Stock - B4B	1 pcs	1/8/19	0.00 0.00	QC 4 - 46	
				Packaging 3 - 1 - B4B	DAS
				Packaging 3 - 2 - B4B	69
				Packaging 3 - 3 - B4B	9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140 DC - 1 - B4B	1 pcs	1/8/19	0.00 0.00	DC - 1 - B4B	DEC 31 2018
				DC - 2 - B4B	
150 QC 21 - FG	1 pcs	1/8/19	0.00 0.00	QC 21 - FG - 21	DEC 31 2018
				QC 21 - FG - 70	

Part Op 130 - Identify and pack for shipping as per PPP D350-600-542 Location: _____
 Descriptions: 140 - (Document Control) Photocopy blue file and create labels as per PPP D350-600-542 chg 002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-5A	Bolt	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5119 258
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5103950
AN310-4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5082904

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

✓ AN4-17	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
✓ AN970-4	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
✓ CR3243-4-3	Cherry Rivet	15 Ea (15 ea)	110-Packaging 1 - Pick Kit
✓ CR3243-4-4	Cherry Rivet	10 Ea (10 ea)	110-Packaging 1 - Pick Kit
✓ D3552-11	Door Prop	1 Ea (1 ea)	110-Packaging 1 - Pick Kit
✓ D3622-3	Ball Stud	2 pcs (2 ea)	110-Packaging 1 - Pick Kit
✓ D3816-1	Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit
✓ D3816-3	Spacer	4 pcs (4 ea)	110-Packaging 1 - Pick Kit
✓ D3956-1	Hinge, Airframe Upper	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3956-3	Hinge, Airframe Lower	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3957-042	Hinge Assembly, Door RH Upper	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3957-044	Hinge Assembly, Door RH Lower	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3968-1	Backiing Plate, Door Hinge	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3968-3	Backiing Plate, Airframe Hinge	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3991-1	Packer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3991-3	Packer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3992-2	Reinforcement	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ D3992-4	Reinforcement	1 pcs (1 ea)	110-Packaging 1 - Pick Kit
✓ MS21042L3	Nut	11 Ea (11 ea)	110-Packaging 1 - Pick Kit
✓ MS24665-212	Cotter Pin	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
✓ MS24693-S275	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
✓ MS24693S274	Screw	2 (2 ea)	110-Packaging 1 - Pick Kit
✓ NAS1149C0363R	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
✓ NAS1149D0363J	Washer	9 Ea (9 ea)	110-Packaging 1 - Pick Kit

F113121
 50110395
 F113449-40
 F104252
 5131620
 F144625
 5140574
 5140339
 F52922
 F52923
 F52925
 5140040
 F52931
 F52932
 F52933
 F52934
 F52936
 F52938
 5132364
 F125044
 5088023
 F124670
 5132615
 5107782

acknow

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-5A	3	195	0
	AN3-6A	2	148	0
	AN310-4	2	162	0
	AN4-17	2	41	0
	AN970-4	2	112	0
	CR3243-4-3	15	183	0
	CR3243-4-4	10	175	0
	D3552-11	1	21	0
	D3622-3	2	14	0
	D3816-1	2	18	0
	D3816-3	4	8	0
	D3956-1	1	7	0
	D3956-3	1	11	0
	D3957-042	1	5	0
	D3957-044	1	3	0
	D3968-1	1	4	0
	D3968-3	1	8	0
	D3991-1	1	17	0
	D3991-3	1	17	0
	D3992-2	1	3	0
	D3992-4	1	3	0
	MS21042L3	11	2,768	0
	MS24665-212	2	132	0
	MS24693-S275	2	100	0
	MS24693S274	2	0	0
	NAS1149C0363R	2	863	0
	NAS1149D0363J	9	1,928	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

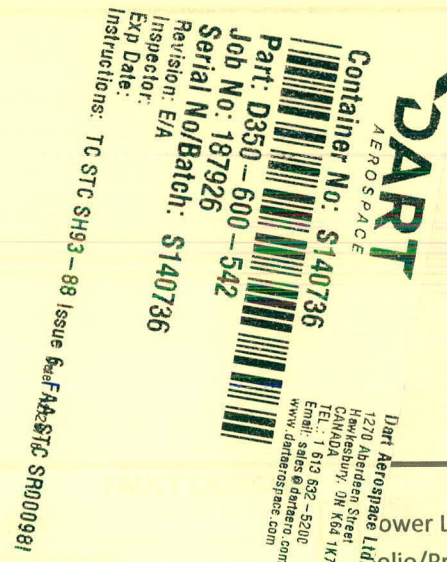


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date : _____		MRB (QS1042)						
Description: _____		Completed By _____						
_____		Lead hand / Supervisor _____						
_____		QC / QA Coordinator _____						
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; vertical-align: top;"> Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ </td> <td style="width: 50%; vertical-align: top;"> Broken ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> </tr> <tr> <td colspan="2" style="vertical-align: top;"> Other/Details: _____ </td> </tr> </table>				Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Broken ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Other/Details: _____	
Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Broken ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐							
Other/Details: _____								



-541	-542	Part Number	Description
X		D350-600-541	LH SLIDING DOOR HINGE KIT
	X	D350-600-542	RH SLIDING DOOR HINGE KIT
1	1	D3956-1	HINGE, AIRFRAME UPPER
1	1	D3956-3	HINGE, AIRFRAME LOWER
1		D3957-041	HINGE ASSEMBLY, LH DOOR UPPER
	1	D3957-042	HINGE ASSEMBLY, RH DOOR UPPER
1		D3957-043	HINGE ASSEMBLY, LH DOOR LOWER
	1	D3957-044	HINGE ASSEMBLY, RH DOOR LOWER
2*	2*	D3815-3	ROD END
2	2	D3816-1	SPACER
4	4	D3816-3	SPACER
1	1	D3968-1	BACKING PLATE
1	1	D3968-3	BACKING PLATE
1	1	D3991-1	PACKER
1	1	D3991-3	PACKER
1		D3992-1	REINFORCEMENT
	1	D3992-2	REINFORCEMENT
1		D3992-3	REINFORCEMENT
	1	D3992-4	REINFORCEMENT
2	2	D3622-3	BALL STUD
1	1	D3552-11	GAS SPRING
3	3	AN3-5A	BOLT
2	2	AN3-6A	BOLT
2	2	AN4-17	BOLT
2	2	AN310-4	CASTLE NUT
2	2	AN970-4	WASHER
15	15	CR3243-4-3	CHERRY MAX RIVET
10	10	CR3243-4-4	CHERRY MAX RIVET
11	11	NAS1149D0363J	WASHER
2*	2*	NAS509-6	NUT
11	11	MS21042L3	NUT
2	2	MS24665-212	COTTER PIN
4	4	MS24693S274	SCREW

* Pre-installed on D3957-041/-042/-043/-044 Hinge Assemblies

4.0 PARTS LIST

The Parts List for the DSI 9814-011/-012 Replacement Hinge Kits is as follows:

QTY -011	QTY -012	Part Number	Description
X		DSI 9814-011	Replacement Hinge Kit, LH
	X	DSI 9814-012	Replacement Hinge Kit, RH
1		D3957-043	Lower Door Hinge Assembly (Rev. B or later)
	1	D3957-044	Lower Door Hinge Assembly (Rev. B or later)
2	2	MS21042L3	Nut
1	1	MS24665-212	Cotter Pin
2	2	MS24693S275	Screw
2	2	NAS1149C0363R	Washer

The Parts List for the D350-600-541/-542 Sliding Door Hinge Kits is revised as follows:

WAS:

QTY -541	QTY -542	Part Number	Description
X		D350-600-541	LH Sliding Door Hinge Kit (at CHG 001)
	X	D350-600-542	RH Sliding Door Hinge Kit (at CHG 001)
1		D3957-043	Lower Door Hinge Assembly (Rev. A)
	1	D3957-044	Lower Door Hinge Assembly (Rev. A)
4	4	MS24693S274	Screw
11	11	NAS1149D0363J	Washer

IS:

QTY -541	QTY -542	Part Number	Description
X		D350-600-541	LH Sliding Door Hinge Kit (at CHG 002 or later)
	X	D350-600-542	RH Sliding Door Hinge Kit (at CHG 002 or later)
1		D3957-043	Lower Door Hinge Assembly (Rev. B or later)
	1	D3957-044	Lower Door Hinge Assembly (Rev. B or later)
2	2	MS24693S274	Screw
2	2	MS24693S275	Screw
2	2	NAS1149C0363R	Washer
9	9	NAS1149D0363J	Washer

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	VS		
CHECKED	RF	DRAWING NO.	DSI 9814
MFG. APPR.	N/A	TITLE	
APPROVED	DSW	REPLACEMENT LOWER HINGE NTS	
DE APPR.	DS	SCALE	
DATE	18.11.30	COPYRIGHT © 2018 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHEET 5 OF 5

Change Record

PAGE 1 OF 1

Part Number: D350-600-542

Description: SLIDING DOOR HINGE, RH

[illegible]

